120

QC

Quality Control

Page 1

(2) 13-03-04 09

January-02-13 11:22:17 AM Item ID: D2161-212 Accept Setup Start \*N900040100\* **Revision ID:** Item Name Mirror Bracket, 212 Start Date: 1/07/13 Start Oty: 2.00 **Cust Item ID:** Required Date: 1/11/13 Rea'd Otv: 2.00 Customer: Reference: Run Process Plan: MLJ Date: \3-01-03 Tooling: Approvals: Stop QC: Date: SPC(Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Accept Reject **Work Center ID** Number Stamp Description **Run Hours** Code Otv Oty Draw Nbr **Revision Nbr** D2161 Rev B2 100 Weld per dwg A/R S.S. rod Batch: M 12 > 357 Q A 13-3-4 -Large Fab \*100\* Large Fab 0.00 Memo Large Fab 1-Assemble on Jig DT8065 as per Dwg D2161 2-Weld as per Dwg D2161 Identify as D2161-212 OC9- Inspect visual per OSI004- Fusion Welds 110 0.00 @ 13-03-04 0AS \*110\* 0.00 OC Memo Quality Control

0.00

0.00

QC5- Inspect part completeness to step on W/O

Memo

												DQA:	Da	ite:			
NCR:	Yes	/ No				WORK ORDER NON-C	100	<b>NFORM</b>	AANCE / UPI	DATE		•	_				
		•									_(	QA Closed:	Da	ite:			
Work Orde	er.					DISPOSITION		AGAINST DEPARTMENT/PROCESS									
Part No						Rework Scrap Use-as-is Work Order Update	Skid-tube Crosstube  Machining Small Fab  Thermoforming Finishing  Large Fab Composite			Prod. Eng. Coor. Rec/Store/Packaging				Engineering Quality Other			
Root					Descri	ption of work order update	Initial	Act	tion	T	Sign &						
Cause		Date	Step	Qty	(	or Non-conformance	Ch	ief Eng	Desci	ription	$\perp$	Date	Verification	'n	QC Inspector		
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved																	
							AUL	T CATE	GORY								
Landi	\$1.7 	Bending Centre No Cracks Crushed/ Cuffs Heat Trea Inspectio	Crimped at n Strip in		o/s	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short		Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance Mislabeled Misread				Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct issing Vrong		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other		
1	1	Ripples in	ı Bend		1	Drill Holes	Offset										

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

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Work Orde January-02-13				*940	152*						Page 2
Item ID: Revision ID: Item Name:	D2161-212 Mirror Bracke	et, 212		Accept	*N900	<b>040</b>	100	)*	Setup	Start Stop	*NS1* *NS2*
Start Date: Required Date: Reference:	1/07/13 1/11/13	Start Qty: 2.00 Req'd Qty: 2.00	*2* *2*		Cust Item I Customer:	D:				~	
Approvals:	Process Pla	an:	Date:			ate:			Run	Start Stop	*NR1* *NR2*
Sequence ID/ Work Center II  130  *120* Powdercoat  Powder Coating	D	Operation Description Black Sandtex(Ref)	780 . 1:50	Set Up/ Run Hours 0.00  0.00  VEN TEMPERATUR	Tool ID	Tool #	Code	Accept Qty	Qty		Reject Insp. Number Stamp
140 *140* QC		QC3- Inspect Part Finis	1	0.00 AS 16 0.00 9-89	3/3/6			R	ر -		

150

\*150\* Packaging

Quality Control

Packaging

Identify as per dwg & Stock Location:

Memo

PPN 94.126 0.00

												DQA:	Da	te: _			
NCR:	⁄es	/ No				WORK ORDER NON-O	COI	NFORM	MANCE / UP	DATE							
												QA Closed:	Da	te:			
Work Orde	or.					DISPOSITION		AGAINST DEPARTMENT/PROCESS									
						Rework Scrap		Skid-tube Machining	Crosstube Small Fab				-	Engineering Quality			
Part No				Use-as-is Work Order Update	s Thermoforming			Finishing Composite		Rec/Store/Packaging Supplier			Other				
Root					Descri	I ption of work order update	T	Initial	Act	tion		Sign &					
Cause		Date	Step	Qty		or Non-conformance	Ch	nief Eng	Desc	ription		Date	Verificatio	n .	QC Inspector		
Doc/Data																	
Equip/Tooling																	
Operator													,		r ,		
Material																	
Setup															•		
Other															* .		
Process					į												
Supplier														ļ			
Training														Ī			
Unapproved							1										
						F	ΑUI	LT CATE	GORY								
Landi	ng C	Sear				General		, , , , , , , , , , , , , , , , , , ,		_		_					
	Ш	Bending				Bend	L	Grain				Ovalized			Pressure/Forced		
	Centre Not Concentric to O/S					BOM/Route	L	Hardwa	re			Over/Under	tolerance		Temperature/Cure		
		Cracks				Broken/Damaged		Inspection Incomplete				Part Incorre	ct		Weld		
		Crushed/	Crimped.			Burrs		Instruct	ions Incomplete/	Unclear		Part Lost/M	issing		Wrong Stock Pulled		
		Cuffs				Contamination		Maintenance				Part Moved		-			

Mislabeled

Out of Calibration
Out of Sequence

Outside Dimensions

Misread

Offset

Positioned Wrong

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Countersink

Cut Too Short

Drill Holes

Drawing

Finish Folio

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Work Order ID 94952 Page 3 January-02-13 11:22:17 AM Accept \*N900040100\* Item ID: D2161-212 Setup Start Revision ID: Stop Mirror Bracket, 212 Item Name: 1/07/13 Start Qty: 2.00 **Start Date:** Cust Item ID: Req'd Qty: 2.00 Required Date: 1/11/13 **Customer:** Reference: Run **Tooling:** Date: Approvals: **Process Plan:** Date: Stop Date:\_\_\_\_\_ SPC (Y/N): Date: Reject
Qty Num.

MUS 13-03-06

MF

13-3-16 **Tool ID** Set Up/ Tool # Plan Sequence ID/ Operation Code **Work Center ID** Description **Run Hours** QC21- Final Inspection - Work Order Release 0.00 160 \*160\* 0.00 QC Memo

Quality Control

										DQA:	Date:					
NCR:	Yes / No	l				WORK ORDER NON-C	MANCE / UP	DATE	QA Closed:	Date:						
Work Order:						DISPOSITION		AGAINST DEPARTMENT/PROCESS								
Part No.  NCR No.						Rework Scrap Use-as-is Work Order Update	Thern	Skid-tube Crosstube  Machining Small Fab  Thermoforming Finishing  Large Fab Composite			Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other				
Root					Descri	ption of work order update	Initial	Ac	tion	Sign &						
Cause	Date	Ste	ep	Qty	c	or Non-conformance	Chief Eng	Desc	ription	Date	Verification	QC Inspector				
Doc/Data																
quip/Tooling																
Operator																
Material			-													
Setup		[														

	FAULT CATEGORY												
Landing Gear General				_		_	<u>-</u> _						
. [	Bending	Bend		Grain		Ovalized	Pressure/Fo	rced					
	Centre Not Concentric to O/S	BOM/Route		Hardware		Over/Under tolerance	Temperatur	e/Cure					
	Cracks	Broken/Damaged		Inspection Incomplete		Part Incorrect	Weld						
	Crushed/Crimped_	Burrs		Instructions Incomplete/Unclear		Part Lost/Missing	Wrong Stoc	k Pulled					
. [	Cuffs	Contamination		Maintenance		Part Moved							
	Heat Treat	Countersink		Mislabeled		Positioned Wrong							
	Inspection Strip in Tube	Cut Too Short		Misread		Power Loss/Surge	Other						
Γ	Ripples in Bend	Drill Holes		Offset									
	Torque Waves in Extrusion	Drawing		Out of Calibration									
	Turning Sequence Finish			Out of Sequence									
	Wave/Twist in Tube	Outside Dimensions											

Other Process Supplier Training Unapproved

## **Picklist Print**

January-02-13 11:22:17 AM

Work Order ID:

94952

Parent Item:

D2161-212

Parent Item Name:

Mirror Bracket, 212

**Start Date: 1/07/13** 

Required Date: 1/11/13

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2013-3 Mirror Bracket LH, 212		Manufactured	No			100	Each	2.0000	1	2 2	/3 - 3	3-4	
				<b>Location</b>		Loc Qty	<u>Lo</u>	c Code					
				WA001	74	2 1 1				/			
D2013-4 Mirror Bracket RH, 212		Manufactured	No	<b>8</b> 5	976 <i>x</i> 多 7	100	Each	0.0000	1	2	3-3-4		
<b>D2037-101</b> Arm		Manufactured	No	03	116221	100	Each	3.0000	1	2 E7	12-3-	<u>4</u>	
				Location		Loc Qty	<u>Lo</u>	c Code					
				WA001 8079	93	3							
				95	836× 2	<b>L</b>							

NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE														
										QA Closed:	Date	•		
Work Orde	er:				DISPOSITION	_	AGAINST DEPARTMENT/PROCESS  Skid-tube Crosstube Water Jet Engineering							
Part I					Rework Scrap Use-as-is Work Order Update	Skid-tube Crosstul Machining Small Formoforming Finishi Large Fab Composi				Prod Rec/Stor	Engineering Quality Other			
Root		1		Descri	tion of work order update	In	itial	Act	tion	Sign &	:			
Cause	Date	Step	Qty		or Non-conformance	Chi	ef Eng	Desci	ription	Date	Verification	QC Inspector		
Doc/Data														
Equip/Tooling														
Operator														
Material			1 1											
Setup														
Other	Ш													
Process										'				
Supplier														
Training	H													
Unapproved			<u> </u>		•	FALLET	CATE	CORY	2					
Landi	ng Gear				General	AULI	CATE	GC/K1						
Latiui	Bending	т			Bend		Grain		<u> </u>	Ovalized	Γ	Pressure/Forced		
•	<u> </u>	, Not Conce	ntric to 0	<sub>o/s</sub>	BOM/Route	$\vdash$	Hardwa	ıre		Over/Under	tolerance	Temperature/Cure		
	Cracks				Broken/Damaged	$\vdash$		ion Incomplete		Part Incorre	<u> </u>	Weld		
	⊢	I/Crimped			Burrs	-	•	ions Incomplete/	Unclear	Part Lost/Mi	<u></u> +-	Wrong Stock Pulled		
	Cuffs				Contamination	-		enance		Part Moved		<u> </u>		
	Heat Tr	eat			Countersink		Mislabe	eled		Positioned V	Vrong	,		
	Inspecti	on Strip ir	Tube		Cut Too Short		Misread	d		Power Loss/	Surge	Other		
	Ripples in Bend				Drill Holes		Offset			<u>-</u>				
	Torque	Waves in	Extrusion	1	Drawing		Out of 0	Calibration						
	Turning	Sequence	<b>:</b>		Finish		Out of 9	Sequence						

Outside Dimensions

DQA:

Date:

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Wave/Twist in Tube

Folio